

Date: Tuesday, 7/17/2007 2:00:56 PM
 User: Kim Johnston

Process Sheet

| | | |
|--|-------------------------------|------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LUG | |
| Job Number : 33595 | | |
| Estimate Number : 11683 | | |
| P.O. Number : N/A | Part Number : D2888 | |
| This Issue : 7/17/2007 S.O. No. : N/A | Drawing Number : D2888 REV A2 | |
| Prsht Rev. : NC | Project Number : N/A | |
| First Issue : N/A | Drawing Revision : A | |
| Previous Run : 29606 | Material : N/A | |
| | Due Date : 8/3/2007 | Qty: 20 Um: Each |
| Written By : _____ | | |
| Checked & Approved By : <u>07.07.17</u> | | |
| Comment : Est. C 00.06.22 Removed P/O for powder coat EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B2500X03500 | 6061-T6 Bar 2.5" x 3.5" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.3938 f(s)/Unit Total : 4.7250 f(s)

6061-T6 Bar 2.5" x 3.5"

Material: 3.5" x 2.5" bar 6061-T6

M102838X9

Batch M14805X12 ml 07/08/29

(21)

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blanks 4.20" long
(Grain along 4.20")

ml 07/08/29

(21)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2888

Deburr and Tumble

ml 07/08/02

20

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/08/02

20

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

ml 07/08/02 (20)

| | | |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1


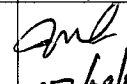



Acid etch and Alodine as per QSI 005 4.1

FL 07/09/12

(20)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/09/14
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---|----------------------------------|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/09/07 | 3 | the dim. 438" are .395" the dim. 375" are one side .355 R.C: Operator put his origin 0.030" off, on the incorrect side. Operator error. |  | Scrap & replace. 1 part only. |  07/09/07 |  070907 |  07.09.07 |  070907 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 33595

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-09-13

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR/FL

07/09/13 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 31470

7/9/13

50

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) 07/09/14

Job Completion



IL 08-09-14

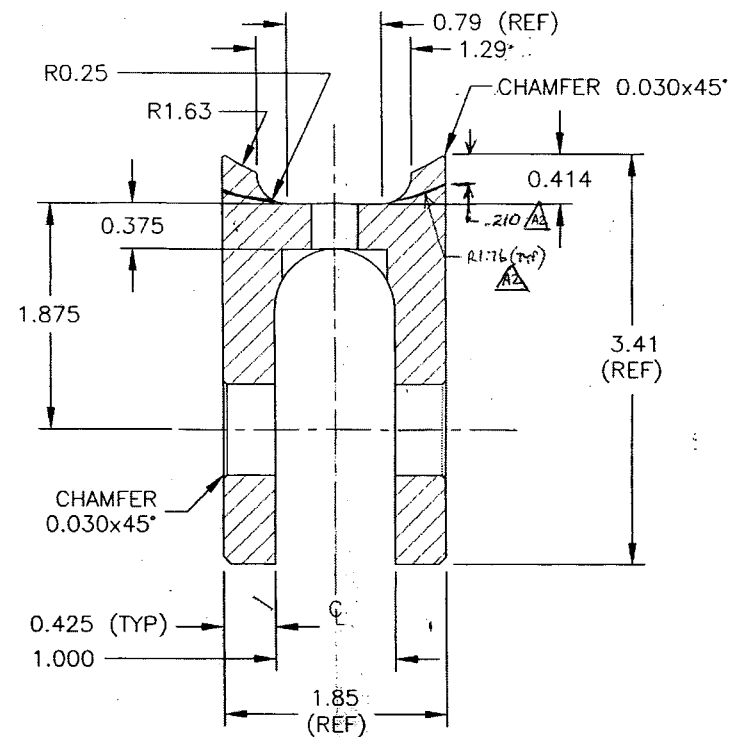
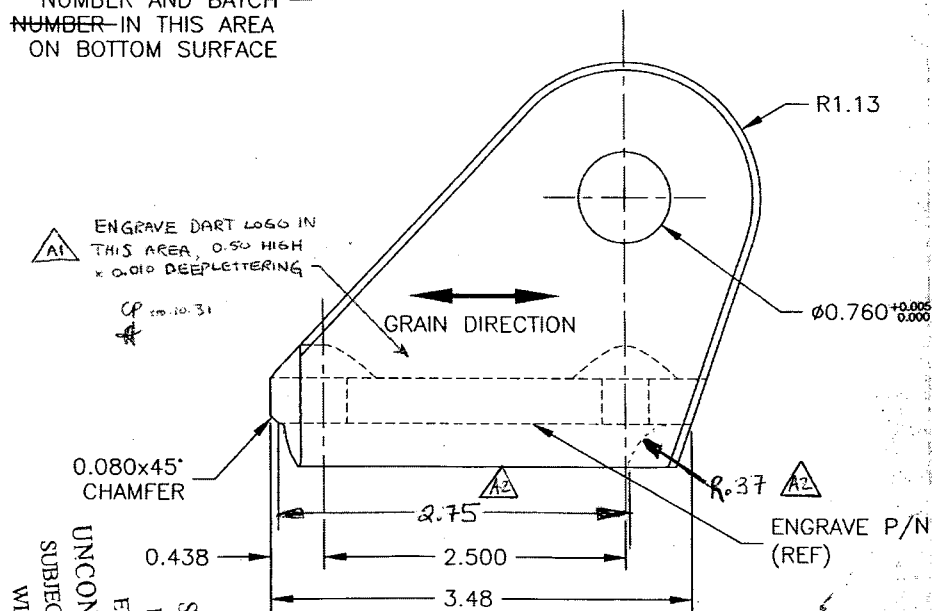
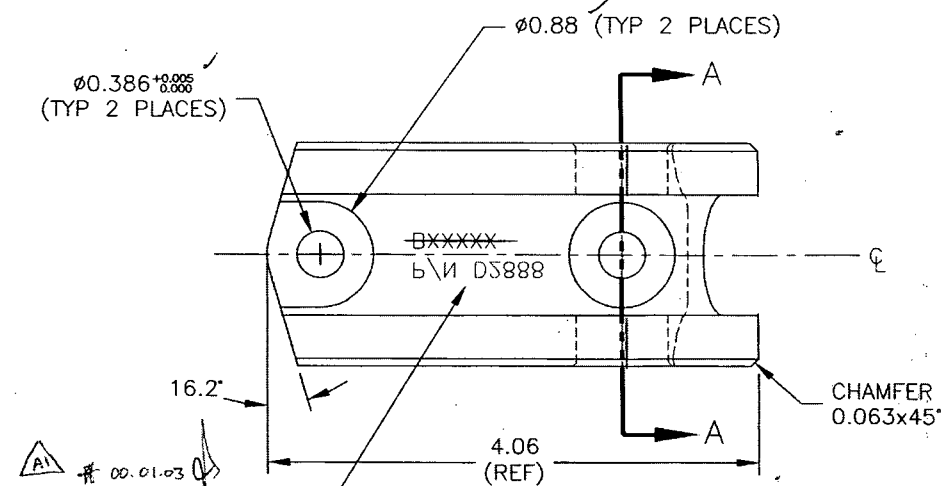
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | |
|----------|----------|-------------|--|
| A | 99.06.21 | NEW ISSUE | |
| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| | | D2888 | SHEET 1 OF 1 |
| DATE | TITLE | SCALE | |
| 99.06.21 | LUG | 1:1 | |

| | | | |
|----|----------|-------------------------------------|--|
| A2 | 04.04.08 | Add Saddle Clearance Per NCR 794 | |
| A1 | 00.10.31 | Update Engraving | |

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NO. 33595
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

| | | |
|------------------------------|--|--------------------|
| DART AEROSPACE LTD | | Work Order: 33595 |
| Description: LUG | | Part Number: D2888 |
| Inspection Dwg: D2888 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-------------------------|------------------|--------|--------|----------------------|----------|
| Ø 0.386 | ± 0.005 -0.006 | Ø 0.388 | — | | | |
| Ø 0.88 | ± 0.036 | Ø 0.881 | — | | | |
| 0.063X45° | ± 0.010 | 0.067X45° | — | | | |
| 4.06 | ± 0.030 | 4.063 | — | | | |
| 3.48 | ± 0.030 | 3.480 | — | | | |
| 2.506 | ± 0.005 | 2.499 | — | | | |
| 0.438 | ± 0.010 | 0.439 | — | | | |
| Ø 0.766 | ± 0.005 -0.000 | Ø 0.766 | — | | | |
| R1.13 | ± 0.030 | R1.128 | — | | | |
| 0.080X45° | ± 0.010 | 0.072X45° | — | | | |
| 1.85 | ± 0.030 | 1.857 | — | | | |
| 1.006 | ± 0.010 | 1.003 | — | | | |
| 0.425 | ± 0.010 | 0.422 | — | | | |
| 0.030X45° | ± 0.030 | 0.025X45° | — | | | |
| 1.875 | ± 0.010 | 1.873 | — | | | |
| 0.375 | ± 0.010 | 0.378 | — | | | |
| R0.25 | ± 0.030 | R0.250 | — | | | |
| 0.79 | ± 0.030 | 0.790 | — | | | |
| 1.29 | ± 0.030 | 1.288 | — | | | |
| 0.414 | ± 0.010 | 0.411 | — | | | |
| 0.216 | ± 0.010 | 0.220 | — | | | |
| 3.41 | ± 0.030 | 3.412 | — | | | |

| | | |
|------------------------|-----------------------|---------------------|
| Measured by: <i>mk</i> | Audited by: <i>gk</i> | Prototype Approval: |
| Date: 07/08/30 | Date: 07.09.01 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |